

Date: Monday, 4/30/2007 7:22:04 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET	
Job Number : 32095		
Estimate Number : 11181		
P.O. Number : N/A	Part Number : D32941	
This Issue : 4/30/2007 S.O. No. : N/A	Drawing Number : D3294 REV A1	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A1	
Previous Run : 31301	Material : N/A	
Written By : _____	Due Date : 5/4/2007	Qty: 4 Um: Each
Checked & Approved By : <u>07.04.30</u>		
Comment : Est A 04.08.24 New issue KJ/JLM		
Est Rev:B Now On Waterjet 07-03-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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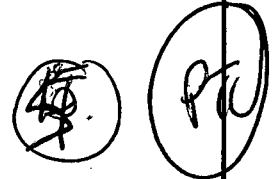
Comment: Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s) **M18481 X3**
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)
Identify for D3294-1
Batch: **M102838** **ml 07/05/15**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3294
Dwg Rev: **A1**
Prog Rev: **A1**

ml 07/05/15



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07/05/15



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S.F 07/05/16 (4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

John 07/05/16 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-15	2.0	1 part scrap. it is Added 1 small large holes, where they are not required, as per Dwg. R.C. Big holes on DXF.	<i>[Signature]</i> 02/10/12	Fix hole size; update DXF. Destroy; replace part & check holes for correct size. No more and!	<i>[Signature]</i> 07/05/15 <i>[Signature]</i> 07/05/15		<i>[Signature]</i> 02/10/12	<i>[Signature]</i> 07-05-15

NOTE: Date & initial all entries

Date: Monday, 4/30/2007 7:22:04 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32095

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

SB 07/05/17

(4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-17 (4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W

07-05-17

(4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

W

07-05-17

(4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

07/05/17 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 273

07/05/17 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/17 (4)

Job Completion



W 07/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

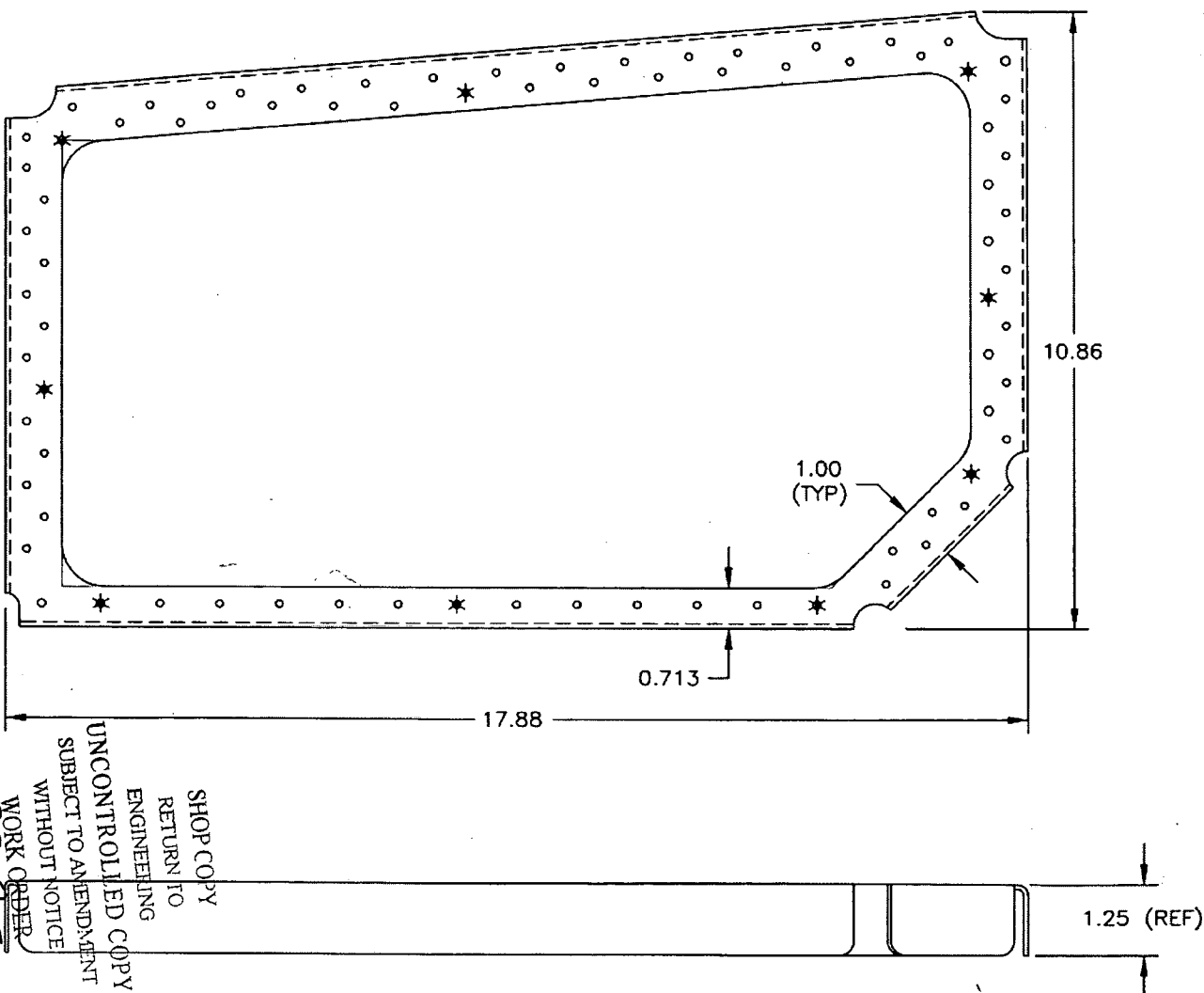
NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A		
<i>CP</i>	<i>CP</i>	D3294	SHEET 1 OF 2		
DATE	TITLE		SCALE		
04.06.28	BRACKET		1:3		
A	04.06.28	NEW ISSUE			
A1	<i>CP</i>	05.06.13	12.97 WAS 13.03, AS MANUFACTURED		

RELEASED
04.07.12 *CP***D3294-1 BRACKET**

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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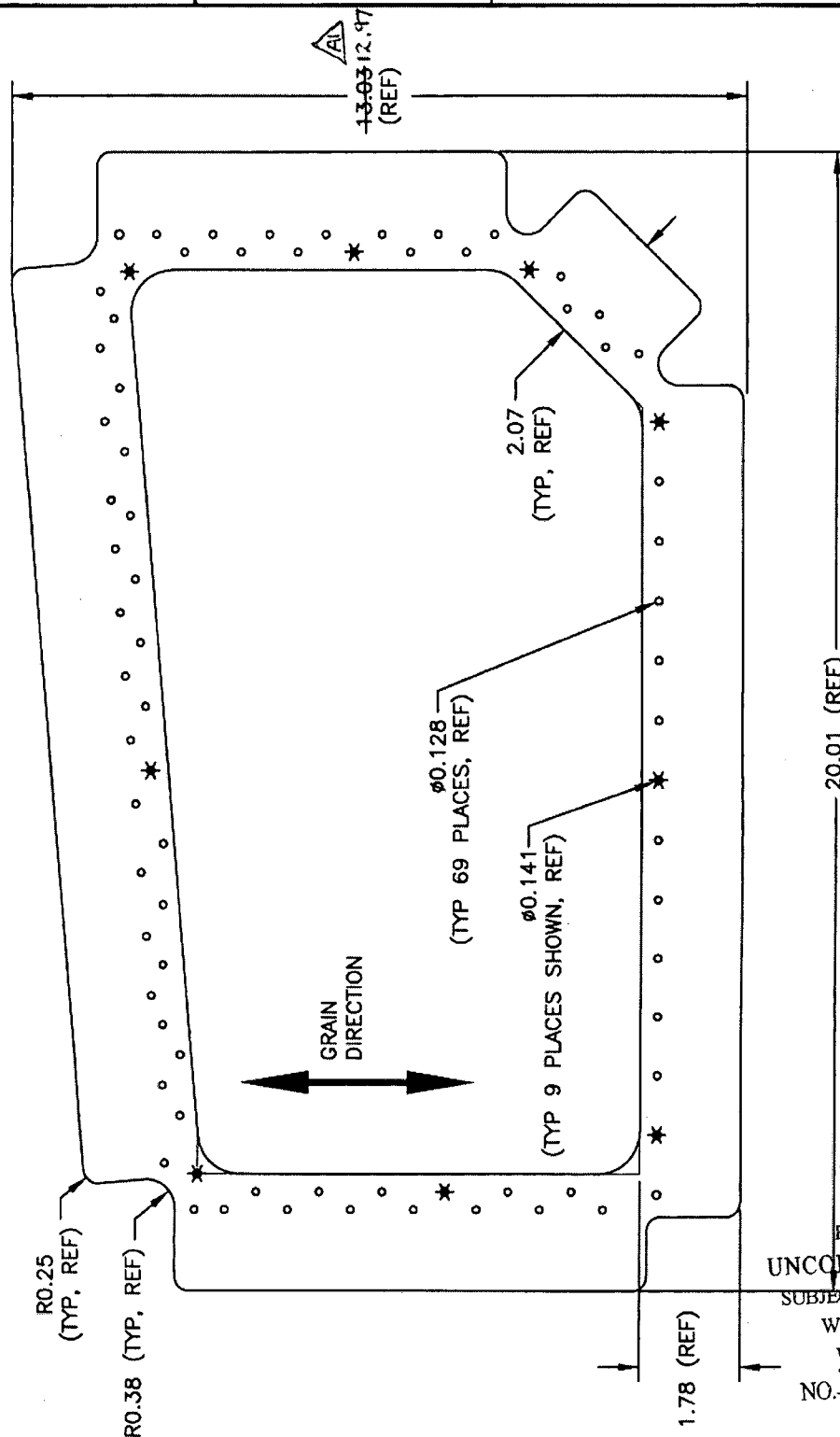
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED
04.07.12



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